

20-7883



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3313

Job Sheet 203825



Part No: 646.3313

Job Qty: 20 pcs

Part Name: Upper Guide



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/27/19

Job Tracking No:

Due Date: 12/23/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A SHEET 7 IPP REV:A NEW ISSUE 12/11/14 JFS VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	20 pcs		12/23/19	0.00	0.45	Bandsaw - 1	52	20/01/04
110	HAAS 4 Axis - B4B	20 pcs		12/23/19	1.20	12.42	HAAS - 1 - B4B	52	20/01/04
							HAAS - 2 - B4B	9-89	
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	20 pcs		12/23/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		20/01/04
							QC 2 - 57		
							QC 2 - 62		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S244753



Part: 646.3313

Job No: 203825

Serial No/Batch: S244753

Revision: Rev A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/04/20

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130 QC 8	20 pcs	12/23/19	0.00 0.00	QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
140 Outsource - 4 - Anodize	20 pcs	12/23/19	0.00 0.00	QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				ATG001-VC	10
150 Packaging 2-1 - Receive - B4B	20 pcs	12/23/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 -	

2020/01/04

2020-01-06

JAN 15 2020

						B4B	
						Packaging 2 - 17 - B4B	
						Packaging 2 - 18 - B4B	
						Packaging 2 - 19 - B4B	
						Packaging 2 - 20 - B4B	
						Packaging 2 - 21 - B4B	
						Packaging 2 - 22 - B4B	
						Packaging 2 - 23 - B4B	
						Packaging 2 - 24 - B4B	
						Packaging 2 - 25 - B4B	
						Packaging 2 - 26 - B4B	
						Packaging 2 - 27 - B4B	
						Packaging 2 - 28 - B4B	
						Packaging 2 - 29 - B4B	
						Packaging 2 - 30 - B4B	
						Packaging 2 - 31 - B4B	
						Packaging 2 - 32 - B4B	
						Packaging 2 - 33 - B4B	
						Packaging 2 - 34 - B4B	
						Packaging 2 - 35 - B4B	
						Packaging 2 - 36 - B4B	
155 QC 6	20 pcs	12/23/19	0.00	0.00		QC 6 - 9	DAS
						QC 6 - 68	JAN 22 2020 68
						QC 6 - 61	9-89
						QC 6 - 40	
						QC 6 - 81	
180 Packaging 3-1 - Stock - B4B	20 pcs	12/23/19	0.00	0.00		Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	DAS 74 JAN 23 2020
						Packaging 3 - 5 - B4B	9-89
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
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					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190 QC 21 - SA	20 pcs	12/23/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 100 - (Bandsaw) Cut Blank at 13.500* *** ONE BLANK MAKES TWO PARTS***

Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FB152

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - Issue P/O to ATG : 45491 Hard Anodize Color Black and Prime as per DWG 646.3300

150 - (Receive & Inspect for Damage & Mat'l Certs)

155 - QC6- All purchased or subcontracted products

180 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S0.375X5.000	M7075T6S0.375 X 5.000	11.2600 ft (.563 ea)	100-Bandsaw - 1	5221695 r2 5203966 x8

Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Bandsaw - 1	M7075T6S0.375X5.000	11	18	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Upper Guide	3.070inches ± 0.010	3.080 3.060	3.07	
2	Upper Guide	12.890inches ± 0.010	12.900 12.880	12.89	
3	Upper Guide	0.375inches ± 0.005	0.380 0.370	0.373	
4	Upper Guide	0.130inches ± 0.010	0.140 0.120	0.130	
5	Upper Guide	45.000Degrees ± 0.500	45.500 44.500	45°	Angle
6	Upper Guide	0.209inches + 0.005 - 0.001	0.214 0.208	0.209	diameter
7	Upper Guide	0.350inches ± 0.005	0.355 0.345	0.350	
8	Upper Guide	1.313inches ± 0.002	1.315 1.311	1.313	

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Tel (613) 632-5200

PURCHASE ORDER

POHB045491



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalonde, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045491

PO Date: 1/6/20

Due Date: 1/17/20

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

RECEIVED
2020-01-13

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	203268	646.2910	646.2900 Rev N/C	Deflector : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG : Hard Anodize, Color Black / Prime As per Dwg 646.2900 Rev. N/C	Firmed	-	1/17/20	10 pcs	0 pcs	10 pcs	\$49.34/pcs	\$493.40
2	204188	RBD29905-15	RBD29905 Rev G	Center Plate (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O -ANODIZE COLOR RED, PER IAW MIL- A-8625 TYPE-2 CLASS-2, Water sealant	Firmed X235	-	1/17/20	23 pcs	0 pcs	23 pcs	\$5.63/pcs	\$129.49

JAN 14 2020



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PURCHASE ORDER

POHB045491



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	203825	646.3313	646.3300 Rev A	Upper Guide : Various STC's Issue P/O to ATG : Hard Anodize Color Black and Prime as per DWG 646.3300	Firmed X13	-	1/17/20	18 pcs	0 pcs	18 pcs	\$14.44/pcs	\$259.92
										JAN 15 2020		DAS 68 9-89
4	204055	D4980-1	D4980 REV.C	Doubler : Various STC's Issue P/O to ATG : AS PER DWG D4980 1- HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK, 2- PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005 Certification of Conformity is required	Firmed X10	-	1/17/20	10 pcs	0 pcs	10 pcs	\$7.59/pcs	\$75.90
										JAN 15 2020		
5	200290	RBE350A93-3302-02-5	RBE350A93-3302-02 Rev M	Extension Handle (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL- A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed X12	-	1/17/20	12 pcs	0 pcs	12 pcs	\$5.63/pcs	\$67.56
										JAN 14 2020		



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PURCHASE ORDER

POHB045491



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	203838	647.3912	647.3900 Rev C2	Breakaway Tip Wirestrike for Wire Strike : Various STC's Issue P/O to ATG : 1- Black Anodize as per Dwg 647.3900 2- PRIME AS PER DWG, SEE NOTE #9 Certification of Conformity is required	Firmed X12	-	1/17/20	12 pcs	0 pcs	12 pcs	\$12.79/pcs	\$153.48
							JAN 15 2020					
7	203839	647.5710	647.5700 Rev N/C	GPS Mount : Various STC's Hard Anodize Black IAW MIL-A-8625 Type III Class 2 Cardinal 4860-50 pre-treatment primer; Prime IAW MIL-P-23377 J Type I Class N; 1-2 mil MAX Outsource process- Anodize per QSI017 4.1.10.1	Firmed X8	-	1/17/20	8 pcs	0 pcs	8 pcs	\$11.39/pcs	\$91.12
										JAN 15 2020		
Grand Total:											\$1,270.87	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/13/20 4:21 PM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number 919392

Date: 15-Jan-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
18 ea	Part: 646.3313 Upper Guide Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot# S 236137 Job: 26715 PO: POHB045491		Rev: A Expiry Date: 05/29/2021 Line: 3 JAN 15 2020 DAS 68 9-89
10 ea	Part: D4980-1 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Batch/Lot# S 236137 Job: 26716 PO: POHB045491		Rev: C Expiry Date: 05/29/2021 Line: 4 JAN 15 2020
12 ea	Part: 647.3912 Breakaway Tip Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5-4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied) (1-2 mils) Batch/Lot# S 236137 Job: 26718 PO: POHB045491		Rev: C2 ✓ Expiry Date: 05/29/2021 Line: 6 JAN 15 2020 RECEIVED JAN 15 2020 DART AEROSPACE LTD.
Made in Canada.			

Made in Canada.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919392

Date: 15-Jan-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
8 ea	Part: 647.5710 GPS Mount Hard Black Anodize per MIL-A-8625, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-P-23377J, Type I, Class N (Customer Supplied), .1-2 Mil max Batch/Lot#: S236137 Job: 26719 PO: POHB045491	Rev: NC Expiry Date: 05/29/2021 Line: 7	 JAN 15 2020
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>JAN 15 2020</u> Certified Signature: _____ Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			

Made in Canada.

• **John Chuprun**

From: David Duval
Sent: Thursday, January 16, 2020 1:09 PM
To: Patrick Duval; John Chuprun
Subject: FW: CCK primer

From: Jacob Becker <jbecker@dartaero.com>
Sent: Thursday, January 16, 2020 1:08 PM
To: David Duval <dduval@dartaero.com>; Steven Drouin <sdrouin@dartaero.com>
Subject: RE: CCK primer

Hi David,

Per our conversation, it is acceptable to reference section 4.2 of MPP-172 PRIMER IAW MIL-PRF-23377 TYPE I CLASS N in place of section 4.3 for purposes of priming the cable cutter body.

Regards,

JACOB BECKER
Project/Sustaining Engineer

DART AEROSPACE
T 1 760 509-1639
M 1 760 691-9108
F 1 760 758-9612
1-800-556-4166
www.dartaerospace.com



From: David Duval
Sent: Thursday, January 16, 2020 8:59 AM
To: Jacob Becker <jbecker@dartaero.com>; Steven Drouin <sdrouin@dartaero.com>
Subject: CCK primer

Hi Jacob.

- We just receive part from a outsource supplier for the Anodize and Primer. They are 646.9710 body. They primed the bodies with the PRIMER IAW MIL-PRF-23377 TYPE I CLASS N as per MPP-172 4.2. instead of the PRIMER CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) that is call on the dwg. Is this acceptable?

Thanks
David Duval

Entered: 26 Date: Feb 10/2020



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 20-7883

Route update only ☐

Job: <u>203825</u> Part No. <u>646.3313</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐					
Date: <u>20/01/04</u>		Sequence #: <u>110</u>		QTY Affected: <u>2</u>			MRB (QSI042)		
Description Work Order Deviation Part moved while machining				Disposition Scrap. and destroy no replace.				Completed By <u>SC</u> <u>20/01/04</u> Lead hand / Supervisor <u>JK</u> <u>20/01/04</u> QC / QA Coordinator <u>AD 20-01-06</u>	
Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☒ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☒ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☒ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
Other/Details:									